

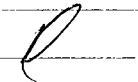
Work Order ID 77106

77106

Page 1

Friday, November 25, 2011 12:39:42 PM

Item ID: D3188-2M Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: SPACEPOD BODY RH
 Start Date: 11/25/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 12/9/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan:  Date: 11-11-25 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3188	Rev F								

100 PURCHASING 0.00
100
 Purchasing
 Purchasing
 Memo
 Issue P/O: 15340
 Description: D3188-2MBODY
 SHIP: QTY (8) D2213 Spacers
 Supplier: Delastek
 Conformity Certificate and Process sheet required
 Ship 2 Items from Previous steps

11-11-25
 (1)

110 Receive & Inspect for Damage & Mat'l Certs 0.00
110
 Packaging
 Packaging
 Memo
 Ensure a copy of certification of conformity and process sheet from Delastek is attached.

11/14/11
 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77106

77106

Page 2

Friday, November 25, 2011 12:39:42 PM

Item ID: D3188-2M Accept ***N900040100*** Setup Start ***NS1***
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 Required Date: 12/9/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing Memo Check for void spot and pins.	0.00 0.00				<i>m</i>	<i>12.02.07</i>	<i>07</i>	<i>0</i>
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: <i>composites</i> Memo	0.00 0.00				<i>RS</i>	<i>12-02-07</i>		
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00					<i>12/2/7</i>	<i>07</i>	<i>0</i>

12-02-7
01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, November 25, 2011 12:39:48 PM

Work Order ID: 77106

77106

Parent Item: D3188-2M

D3188-2M

Parent Item Name: SPACEPOD BODY RH

Start Date: 11/25/2011

Required Date: 12/9/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New issue ecn882 06-11-30 EC
 IPP rev B rev D dwg 07.03.07 ec
 IPP rev C rev E dwg 07.04.16 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2213		Manufactured	No			100	Each	162.0000	8	8			
D2213									**			11-11-25	
Insert													
					<u>Location</u>								
					ST008								
					30809								
D3188-2P		Purchased	No			110	Each	0.0000	1	1			
D3188-2P									**			12-02-07	
Spacepod Body													

77106

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

GENERAL NOTES:

1) MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

1. MOLD SCHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

2) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S.
APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: D3188-1 = N/A
D3188-2 = N/A
D3188-3 = N/A
D3188-5 = N/A
D3188-6 = N/A
D3188-7 = N/A

8) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING

9) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING

SHOP COPY
RETURNED
ENGINEERED
UNCONTROLLED COPY
SUBJECT TO APPROVAL
WITHOUT NOTICE
WORK ORDER
NO. 77106
R11-11-25

RELEASED
2009-10-20
MD

F	REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENTS STANDARDS; ADD CHAMFER IN SECTIONS A-A (ZN C7-10) & H-H (ZN B7-11)	RF	09.07.13
E	ADD HYSOL/ FIBER OPTION ON SHEET 11	CB	07.04.02
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D0600-XXX LABELS	LE	06.12.13
B	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7	CB	06.10.06
A	NEW ISSUE	CP	03.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	#	DRAWING NO.	REV. F
MFG. APPR.	#	D3188	SHEET 1 OF 11
APPROVED	#	TITLE	SCALE
DE APPR.	#	SPACEPOD BODY	NTS
DATE	09.07.13	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

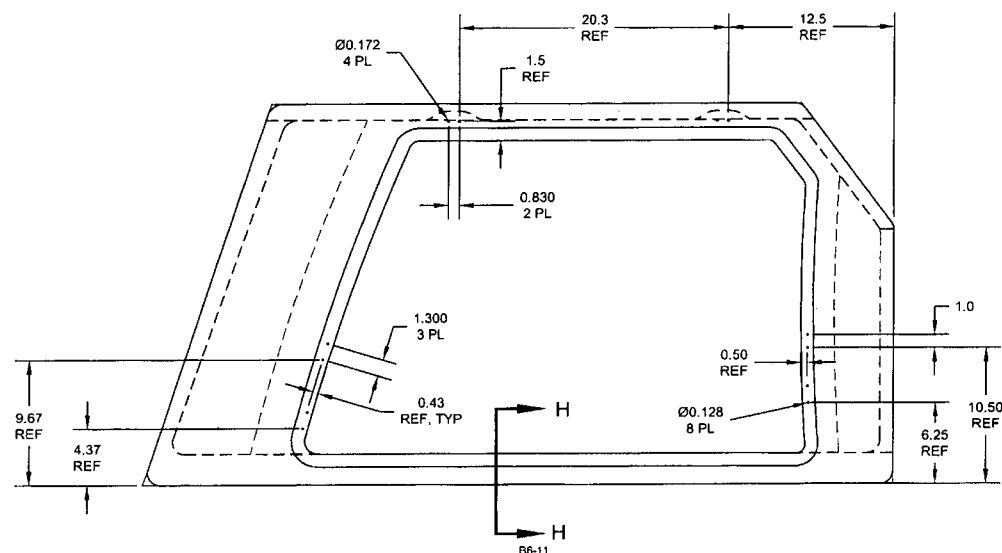
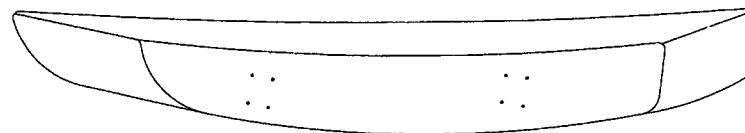
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



77104

RELEASED
2009-10-20
MP

D3188-1 SPACEPOD BODY
MAKE FROM D3188-1M

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	#	D3188	SHEET 2 OF 11
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Dart Aerospace Ltd

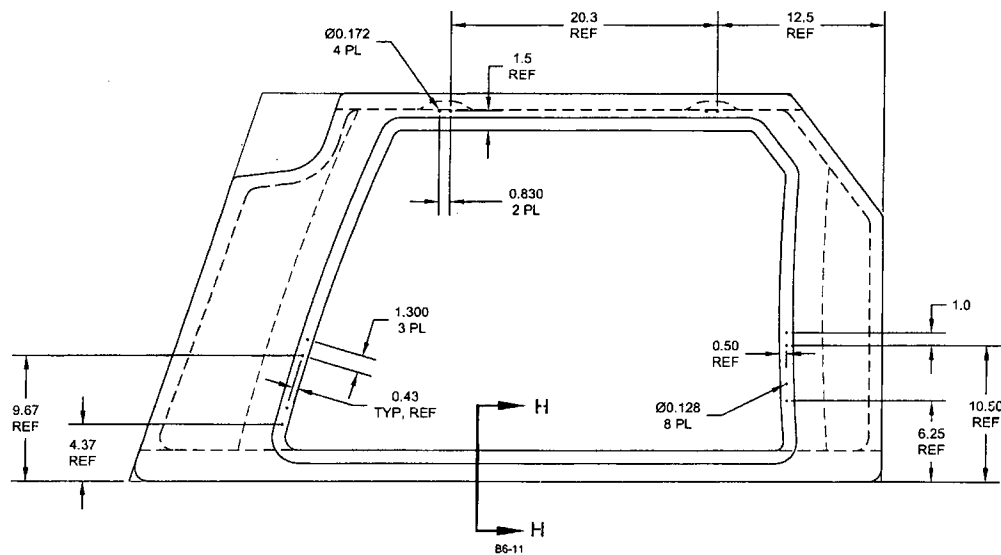
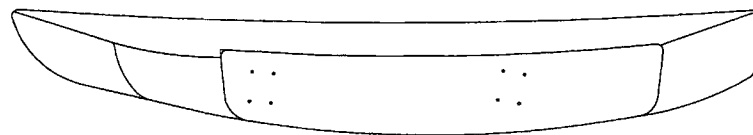
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3188-3 SPACEPOD BODY
MAKE FROM D3188-3M

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

17104

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2009-10-20

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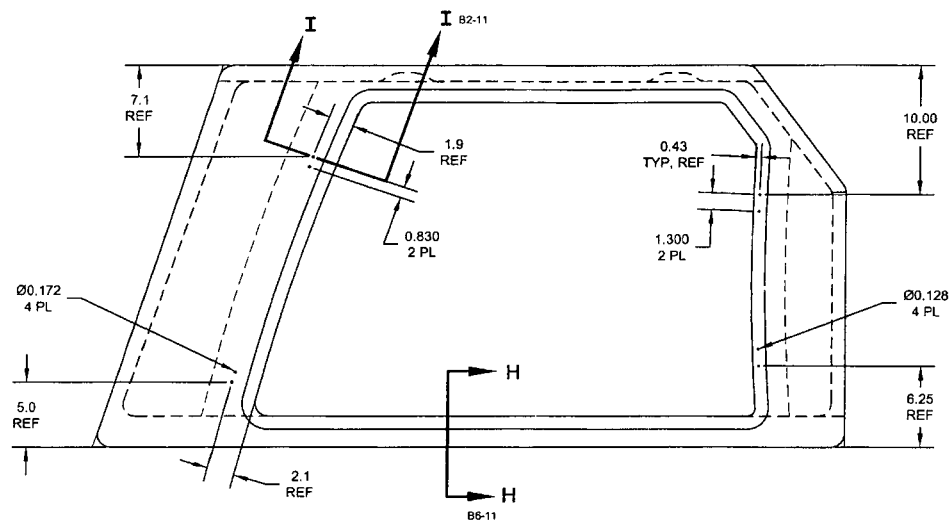
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3188-5 SPACEPOD BODY
MAKE FROM D3188-1M

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3188-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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MFG. APPR.	RF	D3188	SHEET 5 OF 11
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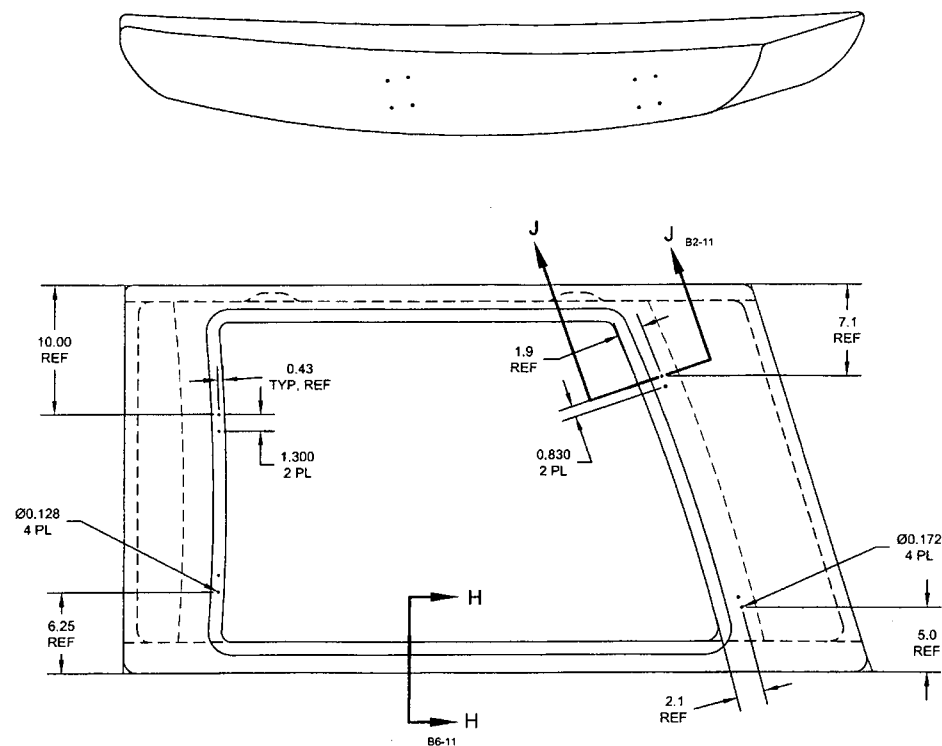
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3188-6 SPACEPOD BODY
MAKE FROM D3188-2M

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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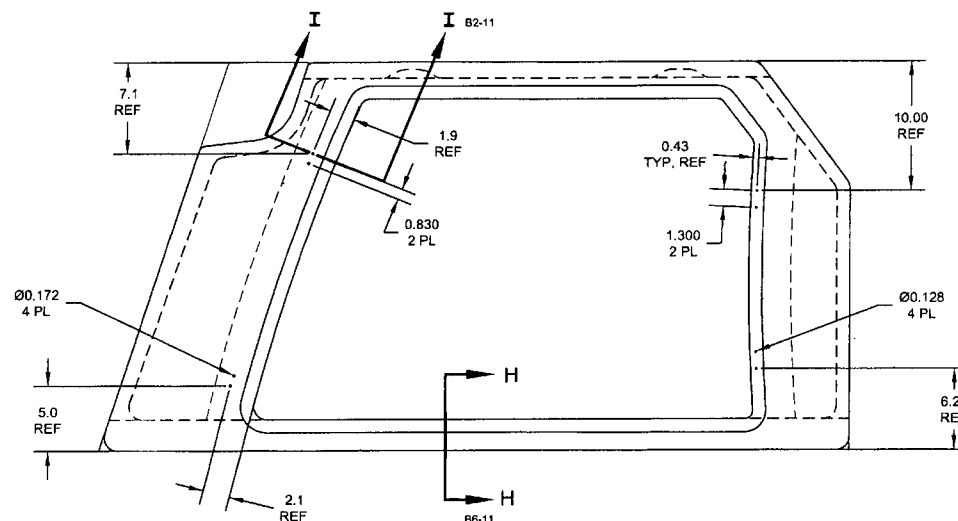
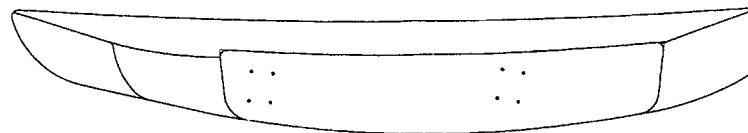
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3188-7 SPACEPOD BODY
MAKE FROM D3188-3M

NOTE:
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE
TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEWS

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MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 7 OF 11
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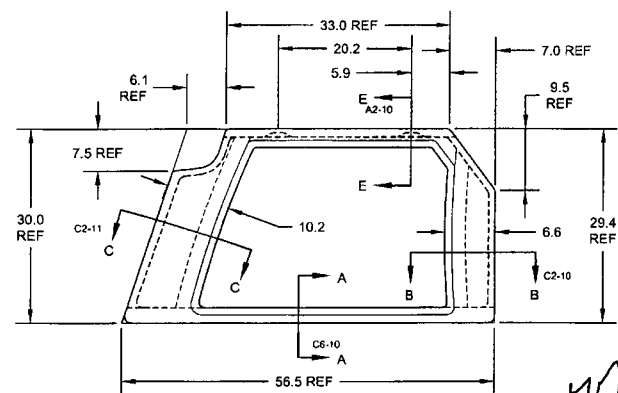
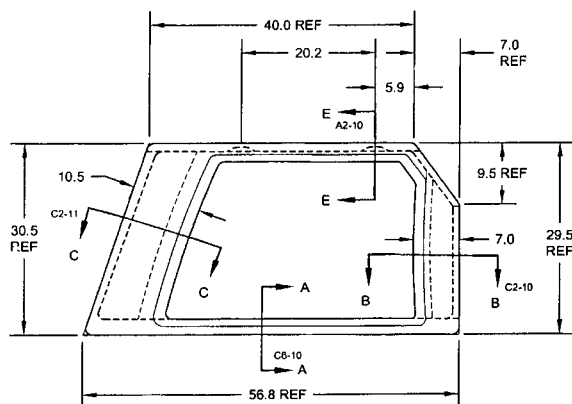
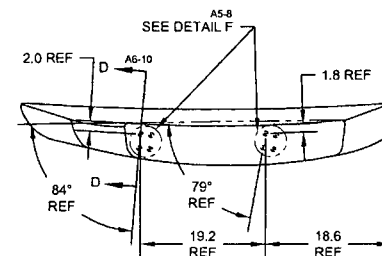
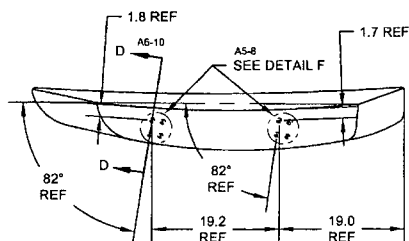
W/O:		WORK ORDER CHANGES					
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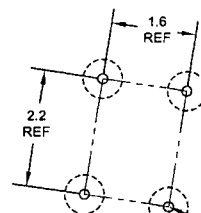
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3188-1M SPACEPOD BODY

D3188-3M SPACEPOD BODY



DETAIL F

INSTALL
D2213 SPACER
8 PL
SEE SECTION D-D
A6-10

D3188-1M/-3M NOTES:

- 1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
- 2) SEE SHEET #10 FOR SECTION VIEWS.

RELEASED
2009-10-20

DESIGN	JB	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. F
MFG. APPR.		D3188 SHEET 8 OF 11
APPROVED		TITLE SCALE
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DATE	09.07.13	COPYRIGHT © 2003 BY DART AEROSPACE LTD
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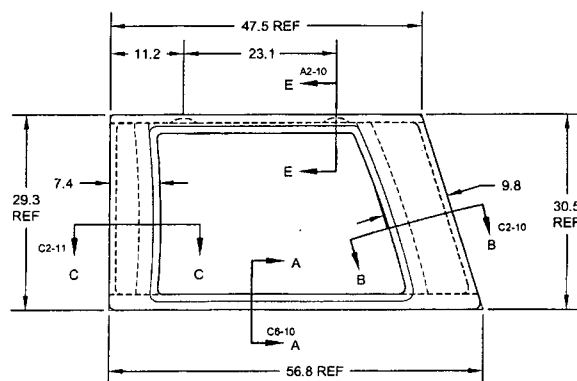
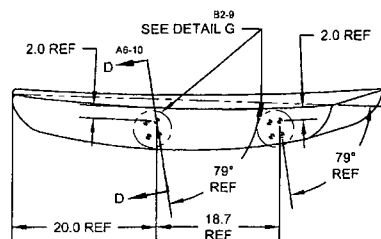
W/O:		WORK ORDER CHANGES					
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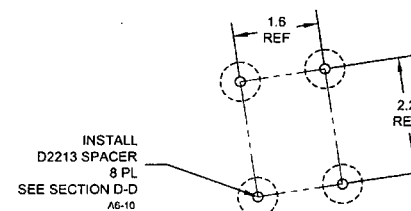
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3188-2M SPACEPOD BODY



DETAIL G D6-9

77106

RELEASED
2009-10-20

D3188-2M NOTES:

- 1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
- 2) SEE SHEET #10 FOR SECTION VIEWS.

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3188	SHEET 9 OF 11
APPROVED		TITLE	SCALE
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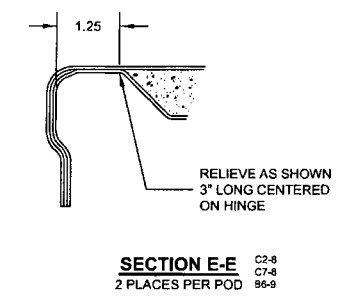
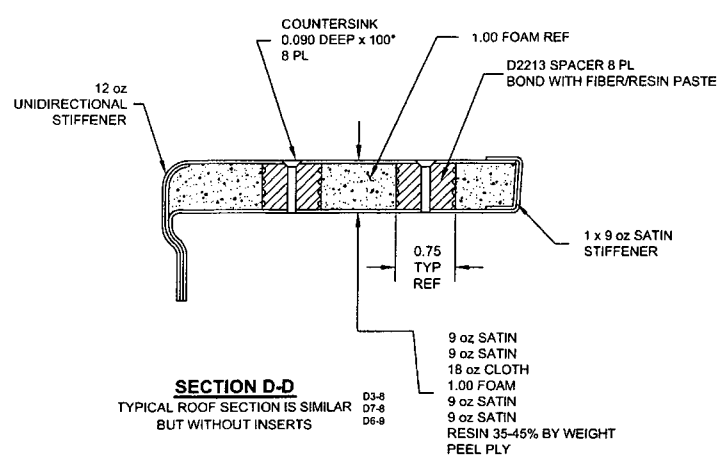
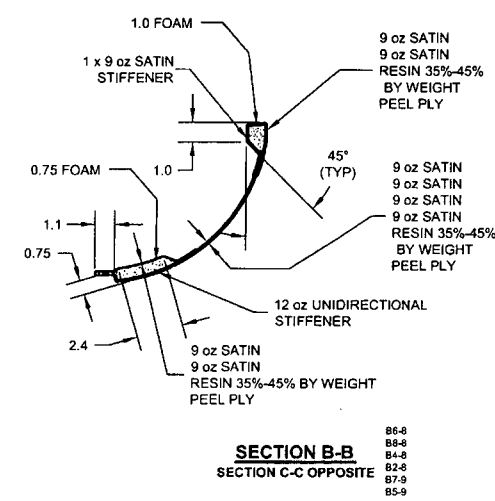
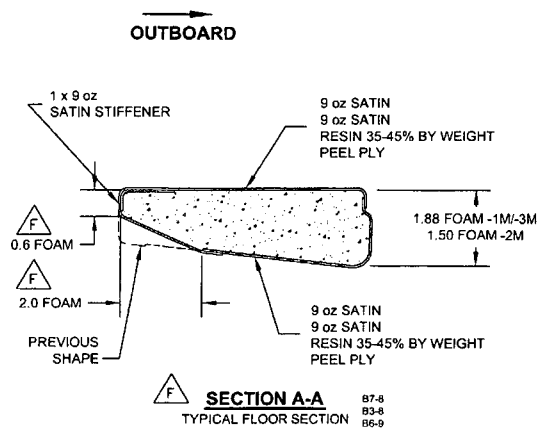
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



77106

RELEASED
2009-10-20

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. F
MFG. APPR.	RF	D3188	SHEET 10 OF 11
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	SPACEPOD BODY	NTS
DATE	09.07.13	COPYRIGHT © 2003 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS COVENANT THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

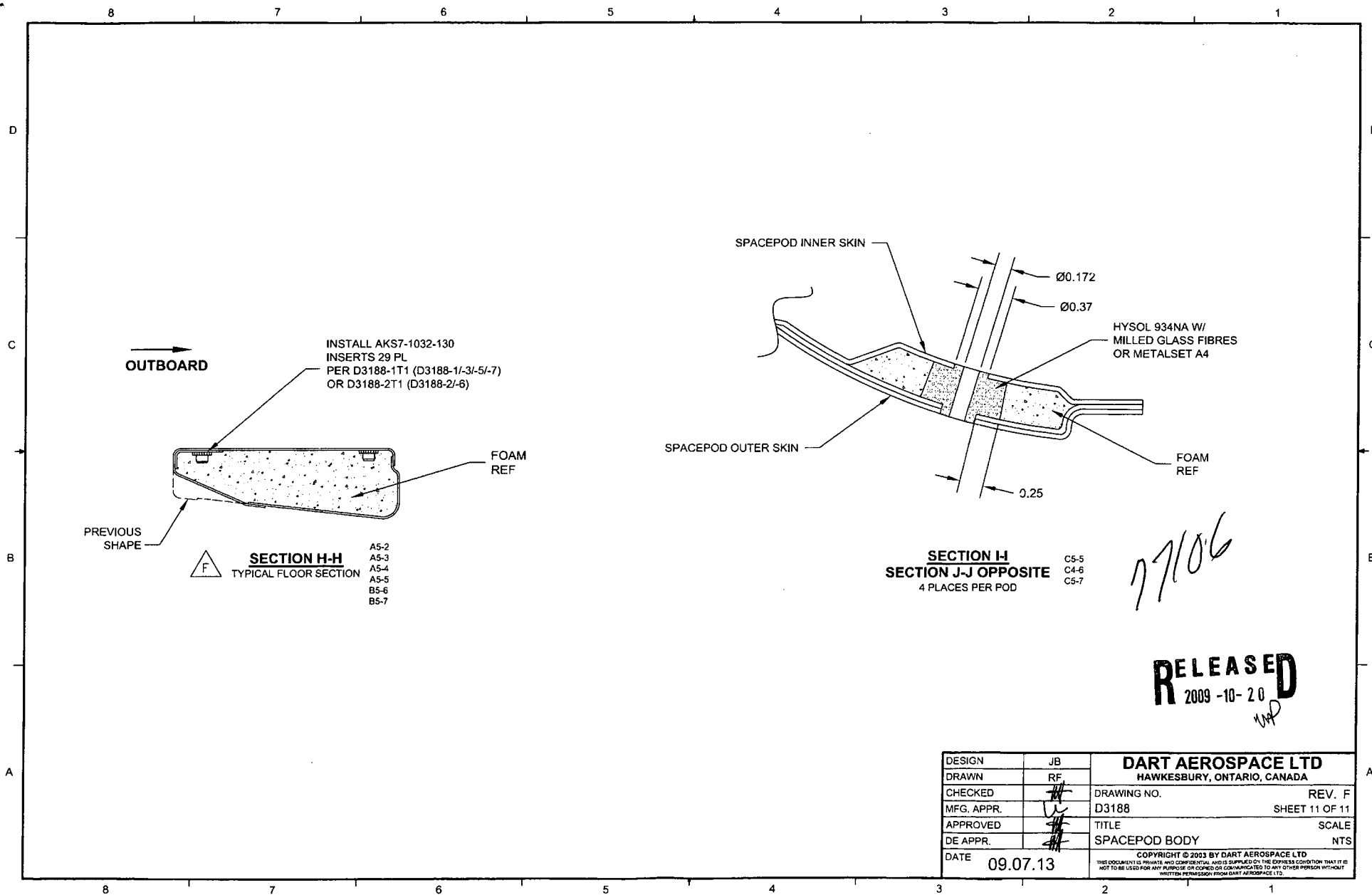
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Delastek inc.
2699 5e avenue
Local 14, Porte -A-
Grand-Mère, Québec G9T 5K7
Can ** Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	41834
Customer #	DART US

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Ship to:

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone: 613-632-5200

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
PURO GROUND		Origin		Net 30 days USA		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #		GST/PST #
13/01/2012	28/11/2011	19399	Brigitte Golden		PO15540		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0071	Line #1 N° D3188-2, Spacepod Body RH B77106 U de M : Each Dwg. D3188 Rév.: F B77106 <u>No. série</u> 36815 <u>No. lot</u> 36815			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by:

Quality department AQ-357

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Date: Jeudi, 2011-10-27 12:26:09
 Utilisateur: Pascal Carignan

Feuille de Procédé

 Client : DART US DART AEROSPACE LTD
 Numéro Job : 36815
 Numéro Soumission : 3763
 Numéro B.A. :
 Cette fois : 2011-10-27 No. B.V. :
 Prsht Rev. : NC
 Prem. fois : - - Type :
 Job précédente : 34495

 Nom Dessin : SPACEPOD BODY RH
 Numéro Article : DKC134-0071
 Numéro Dessin : D3188
 Projet Numéro : DK-362
 Révision dessin : F
 Matériel : Fibre 7781 et résine 411-350
 Date Dûe : 2011-11-03 Qté: 1 Udm: UNITE

 Écrit par :
 Vérifié & Approuvé par :
 Commentaires : N° de pièce Client: D3188-2M

 Process Sheet Rév.: 05 Supprimer les seq 17 AMB0212, seq. 18
 AMB0286 et seq. 19 AAC1611, AAC1885 était AC0883, AAC1887
 était AC0884

Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
1.0	AAC1616	N° 83634, Frekote Loctite Wolo

 Commentair Qty.: 0.050 UNITE(s)/Unit Total : 0.050 UNITE(s)
 N° 83634, Frekote Loctite Wolo N° de Lot: 1-30942-1

2.0	PRÉPARATION	Préparation du moule
-----	-------------	----------------------



Commentair Setp: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation du moule selon IF134-0020.



1 COUCHE Date: 05-12-11 Sceau:

3.0	AAC1885	Tissu à délaminer Release ply B
-----	---------	---------------------------------

 Commentair Qty.: 9.84 VERGE(s)/Unit Total : 9.84 VERGE(s)
 Tissu à délaminer Release ply B # de Lot: 1-30217-1

4.0	AAC1887	Wrightlon 5200 Bleu P3
-----	---------	------------------------

 Commentair Qty.: 9.27 VERGE(s)/Unit Total : 9.27 VERGE(s)
 Wrightlon 5200 Bleu P3 # de Lot: N/A

5.0	AC0885	Feutre de drainage N° Airweave N 10
-----	--------	-------------------------------------

Commentair Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)

6.0	AC0943	Stretchlon 200 poche à vide Vert
-----	--------	----------------------------------

Commentair Qty.: 7.00 VERGE(s)/Unit Total : 7.00 VERGE(s)

7.0	AMB0214	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish
-----	---------	---

 Commentair Qty.: 11.4 VERGE(s)/Unit Total : 11.4 VERGE(s)
 9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish N° de Lot: 1-31000-2

Date: Jeudi, 2011-10-27 12:26:09
Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 36815

Nom Dessin: SPACEPOD BODY RH
Numéro Article: DKC134-0071

Numéro Job:



Ség.: Machine ou Opération: Description :

8.0 AMB0349 Fiberglass 12 oz Unidirectional

Commentair Qty.: 0.80 VERGE(s)/Unit Total : 0.80 VERGE(s)
Fiberglass 12 oz Unidirectional N° de Lot: 1-22549-1

9.0 AMB0213 WR1850 Roving 18oz. x 50"

Commentair Qty.: 0.350 KILOGRAMME(s)/Unit Total : 0.350 KILOGRAMME(s)
WR1850 Roving 18oz. x 50" N° de Lot: 1-32516-1

10.0 AC0886 Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 4.0000 ROULEAU(s)/Unit Total : 4.0000 ROULEAU(s)

11.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs

Tailler les tissus selon IF134-0020.

Date: 5-12-11 Sceau:



12.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.0640 GALLON(s)/Unit Total : 0.0640 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27829-1

13.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 2.000 LITRE(s)/Unit Total : 2.000 LITRE(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-32912-1

14.0 AAC1540 Fibre de verre Miapoxy 66

Commentair Qty.: 0.0040 GALLON(s)/Unit Total : 0.0040 GALLON(s)
Fibre de verre Miapoxy 66 N° de Lot: 1-31393-1

15.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Laminer la 1ère coquille selon IF134-0020.

Date: 5/12/11 Sceau:



16.0 AMB0355 ATC core-cell A500 plain 4'x8' 1" thick

Commentair Qty.: 0.750 FEUILLE(s)/Unit Total : 0.750 FEUILLE(s)
ATC core-cell A500 plain 4'x8' 1" thick N° de Lot: 1-26978-2

17.0 TAILLAGE Faire le taillage du matériel



Commentair Setup: 0.00Hrs/ Run: 120.0000Min Total Run : 2.0000Hrs

Tailler et ajuster les Foam Core selon IF134-0020.

Date: 9-12-11 Sceau:



Date: Jeudi, 2011-10-27 12:26:09
Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 36815

Nom Dessin: SPACEPOD BODY RH
Numéro Article: DKC134-0071

Numéro Job:



Séq.: Machine ou Opération: Description :

18.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.136 KILOGRAMME(s)/Unit Total: 0.136 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-33219-1

19.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.0096 GALLON(s)/Unit Total: 0.0096 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27822-1

20.0 FINITION Finition Générale



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs

Sceller les foam core selon IF134-0020.

Date: 9-12-11 Sceau:



21.0 PERCAGE

Perçage de trous



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Percer les foam core selon IF134-0020.

Date: 12/12/11 Sceau:



22.0 AAC1611

Polybond B46F

Commentair Qty.: 0.078 KIT(s)/Unit Total: 0.078 KIT(s)
Polybond B46F N° de Lot: 1-27795-1

23.0 ASSEMBLAGE

Assemblage mécanique



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

Installer les foam core selon IF134-0020.

Date: 12-12-11 Sceau:



24.0 AAC1492

N° P-15-3, Adtech Micro Ultra Filler

Commentair Qty.: 0.050 GALLON(s)/Unit Total: 0.050 GALLON(s)
N° P-15-3, Adtech Micro Ultra Filler # de Lot: 1-33224-1

25.0 FINITION

Finition Générale



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Usiner les foam core selon IF134-0020.

Date: Jeudi, 2011-10-27 12:26:09
Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 36815

Nom Dessin: SPACEPOD BODY RH
Numéro Article: DKC134-0071

Numéro Job:



Séq.: Machine ou Opération: Description :

Date: 13-11-11 Sceau:



26.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 1.600 KILOGRAMME(s)/Unit Total : 1.600 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-33579-1

27.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.0536 GALLON(s)/Unit Total : 0.0536 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27829-1

28.0 LAMINAGE Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs

Laminer les plis de 9oz selon IF134-0020.

Date: 21/12/11 Sceau:



29.0 TRIMAGE Trimage



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

Faire le taillage selon IF134-0022.

Date: 30/11/12 Sceau:



30.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.0144 GALLON(s)/Unit Total : 0.0144 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27829-1

31.0 AAC1540 Fibre de verre Miapoxy 66

Commentair Qty.: 0.0420 GALLON(s)/Unit Total : 0.0420 GALLON(s)
Fibre de verre Miapoxy 66 N° de Lot: 1-31393-1

32.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.450 KILOGRAMME(s)/Unit Total : 0.450 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-33579-1

33.0 LAMINAGE Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 55.0000Min Total Run : 0.9167Hrs

Faire le laminage des derniers plis 9oz selon IF134-0020.

Date: 06-01-13 Sceau:



Date: Jeudi, 2011-10-27 12:26:10
Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 36815

Nom Dessin: SPACEPOD BODY RH
Numéro Article: DKC134-0071

Numéro Job:



Séq.: Machine ou Opération: Description :

34.0 AAC1610 Spacer N° D2213

Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)
Spacer N° D2213 N° de Lot: 1-33441-1

35.0 ASSEMBLAGE Assemblage mécanique



Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs

Faire l'assemblage des inserts selon IG 0097.

Date: 9/01/12 Sceau:



36.0 AAC1021 Dupont Primer N° 7704S

Commentair Qty.: 0.5000 UNITE(s)/Unit Total : 0.5000 UNITE(s)
Dupont Primer N° 7704S N° de Lot: 1-3117-3

37.0 AAC1101 N° 7775S, Dupont Activator - Reducer Chromabase

Commentair Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-31394-2

38.0 FINITION Finition Générale



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Préparer la pièce selon IG 0008.

Date: 11/01/12 Sceau:



39.0 PRIMER Application primer



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Préparer et appliquer le primer selon IG 0008.

Date: 11/01/12 Sceau:



de fiche de mélange: N/A

40.0 AAC1492 N° P-15-3, Adtech Micro Ultra Filler

Commentair Qty.: 0.010 GALLON(s)/Unit Total : 0.010 GALLON(s)
N° P-15-3, Adtech Micro Ultra Filler # de Lot: 1-33734-1

41.0 FINITION Finition Générale



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs

Faire les réparations de finition s'il y a lieu selon IG 0008.

Date: 12/01/12 Sceau:



Date: Jeudi, 2011-10-27 12:26:10
Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 36815

Nom Dessin: SPACEPOD BODY RH
Numéro Article: DKC134-0071

Numéro Job:



Séq.: Machine ou Opération: Description :

42.0 AAC1021 Dupont Primer N° 7704S

Commentair Qty.: 0.5000 UNITE(s)/Unit Total : 0.5000 UNITE(s)
Dupont Primer N° 7704S N° de Lot: 1-31117-3

43.0 AAC1101 N° 7775S, Dupont Activator - Reducer Chromabase

Commentair Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-31394-2

44.0 PRIMER Application primer



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Préparer et appliquer le primer selon IG 0008.

Date: 12/01/12 Sceau: 35 # de fiche de mélange: N/A

45.0 INSPEC FINAL Inspection finale



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire l'inspection générale de la pièce selon le dessin par le département de la qualité.

Date: 13-01-12 Sceau: 35 Initiales: J.S.

46.0 EMBAL / ENTREPO Emballage & Entreposage



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'emballage selon IG 0057.

Date: 13/01/12 Sceau: 16



2699, 5E AVENUE, LOC. 14, C.P. 123, GRAND-MÈRE, QUÉ, G9T 5K7
 TEL : 819-533-5788 FAX : 819-533-3494
 email : delastek @ delastek.com

AQ-5

INSPECTION REPORT

INSPECTION REPORT NAME : INDKC134-0071.doc

PRODUCT IDENTIFICATION	
DELASTEK	Cage Code : 3AR20
Spacepod body RH	
TECHNICAL CONFIGURATION	
CUSTOMER : DART	P/N DELASTEK : N/A
SUPPLIER CODE : VU-DEL0003	REFERENCE DELASTEK : DKC134-0071
P/N CUSTOMER: D3188-2	NEXT LEVEL : N/A
ACCEPTANCE TEST PROCEDURE : N/A	DRAWING # : D3188 REV : F
ACCEPTANCE TEST SHEET : N/A	PART LIST # : D3188 REV : F
PURCHASE ORDER MANAGEMENT	
P.O. : N/A	P.O REV.: N/A
PACKING SLIP : N/A	UNINCOPR EOs : N/A
MEPI : N/A	PHYSICAL CHANGE : N/A
MFG DATE : N/A	WORK ORDER : 36815
SERIAL NUMBER:	OTHER DOCUMENTATION : N/A

☐ FIRST ARTICLE

☒ FINAL INSPECTION

PART LIST				
Qty	DESCRIPTION	PART NUMBER	LOT NO.	COMMENTS
Vérifiée à partir de la feuille de procédé				

INSPECTION					
OPERATION	ACC.	REJ.	% INSP.	METHOD OF INSPECTION	COMMENTS
Tap test dans les zones de foam	1	0	100	Visuel	DELASTEK QA-11
Primer	1	0	100	Visuel	DELASTEK QA-11
Pas d'identification	1	0	100	Visuel	DELASTEK QA-11



1000, rue de la Vallée

2699, 5E AVENUE, LOC. 14, C.P. 123, GRAND-MÈRE, QUÉ, G9T 5K7
TEL : 819-533-5788 FAX : 819-533-3494
email : delastek @ delastek.com

AQ-5

INSPECTION REPORT

INSPECTION REPORT NAME : INDKC134-0071.doc

FINAL ACCEPTANCE BY:



J.S.

DATE :

13-Jan-2012

QUANTITY : ACCEPTED :

1

REFUSED:

0

NCR# :

N/A

COMMENTS :